

5/04

SPLIT

DART AEROSPACE LTD	Work Order:	22032
Description: Fuel Purge Canister	Part Number:	D3262-041
Dwg: D3262 Rev. A	Qty:	1 <i>+2</i>

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1; (2) D3262-3	<i>JH</i>	04.12.08	12
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: <i>M11409</i>	<i>EP</i>	04/12/15	4
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	<i>EP</i>	04/12/21	4
4	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	04.12.21	4
5	QC8	Second check	<i>EP</i>	04.12.21	4
6	MV	Deburr	<i>EP</i>	04/12/21	4
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: <i>M15362</i>	<i>EP</i>	04/12/21	2
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod <i>M15407</i>	<i>PD</i> <i>DD</i>	04-12-21 04/12/21	2
9	QC5	Inspect work to Step 8	<i>EP</i>	04.12.21	2
10	PG	Issue P/O: <i>2007349</i> For Liquid Penetrant inspection as per Dwg D3262, QSI 038 & as per ASTM E1417 Level 1 <i>Air Penetrate test @ 5 psi</i> Possible Supplier: NDT <i>Submerge in water</i> Copy of NDT results is required.		04/12/21	2
11	RG	Receive and Inspect for transit damage Ensure copy of NDT results are attached.	<i>CL</i>	05/01/10	2
12	QC6	Inspect for damage and ensure results are as per Dwg D3262	<i>WB</i>	05/01/13	1
13	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>ML</i>	05/07/13	1
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	<i>ML</i>	05/07/14	1
15	QC3	Inspect Powder Coat	<i>CL</i>	05/01/17	1
16	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	<i>CL</i>	05/01/17	1
17	AC	Cost / part: <i>439.77 326.81</i>	<i>SAC</i>	05-05-18	1
18	DC	Close W/O <i>439.77</i> Inspect Level 21	<i>JH</i>	05.01.24	1

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	<i>Jeff</i>

RELEASED
Jeff 01-09-19

137.16

7166.7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	22032
Description: Cap	Part Number:	D3262-3
Inspection Dwg: D3262	Rev: A <input checked="" type="checkbox"/> B <input type="checkbox"/>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: EP
Date: 04/17/20

Audited by: E
Date: 06.12.21

Prototype Approval:	N/A
Date:	N/A

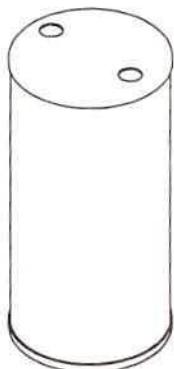
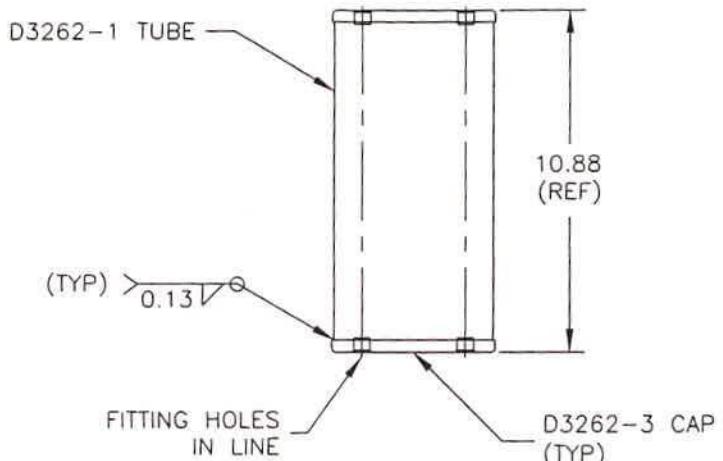
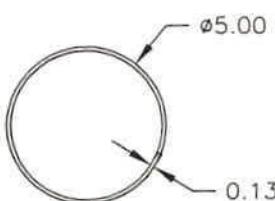
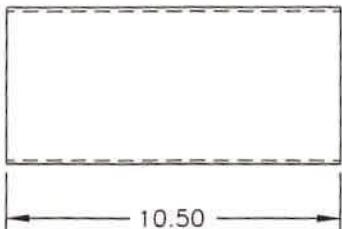
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	P/O D3262-041	KJ/JLM

H:\FORMS\Quality Assurance\approved QA\FAI revD

RELEASED
2004-09-08

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3262	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06 NEW ISSUE		

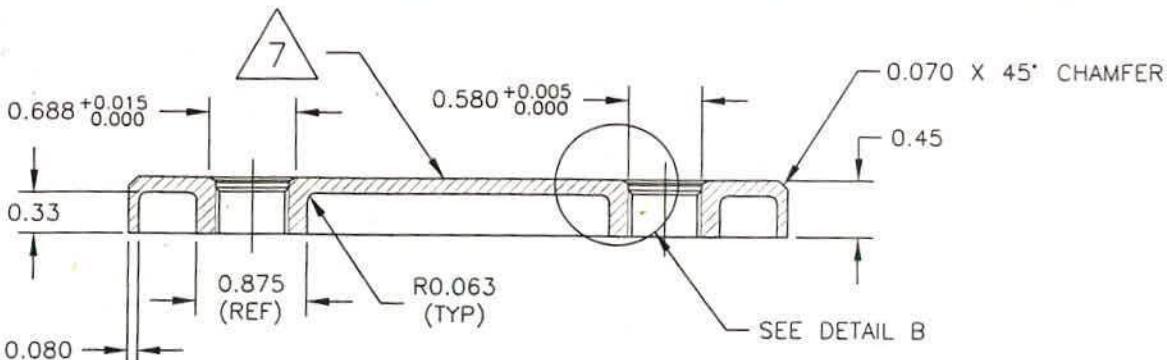
RELEASED
24-07-09 #

D3262-041 CANISTER ASSEMBLY

D3262-1 TUBE
D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

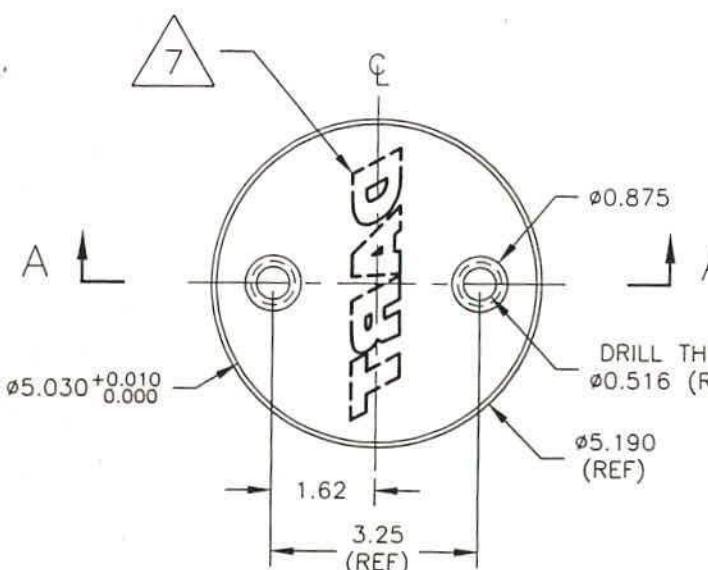
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 22032

DART

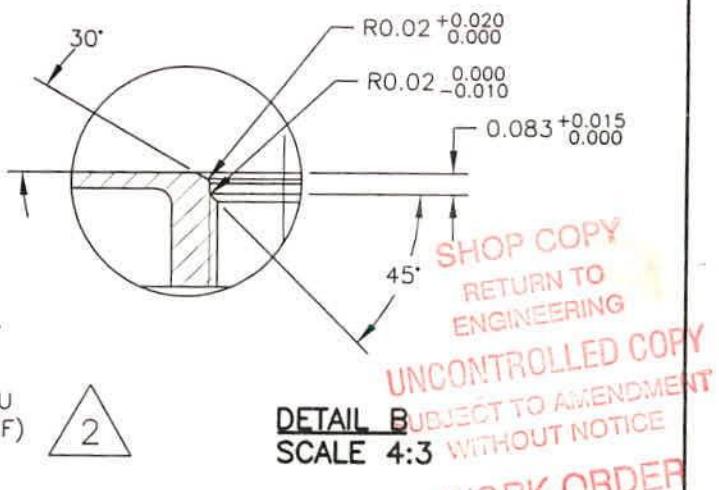
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE FUEL PURGE CANISTER	SCALE 1:3



SECTION A-A
SCALE 2:3



D3262-3 CAP



RELEASED
04.07.04

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022032
 Project Name : D3262-041
 Project For : WK504
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3262-041
 Description : Fuel Purge Canister
 Manufactured : Yes
 Amount Req'd : 12
 Amount Done : 0
 Start Date : 12-03-04
 Est Finish Date : 01-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var.	%	Posted	To Post
Material Cost :	0.00	0.00	0.00		0.00	0.00
Engineering Hours :	0.00	0.00	0.00			
Engineering Cost :	0.00	0.00	0.00		0.00	0.00
Production Hours :	0.00	0.00	0.00			
Production Cost :	0.00	0.00	0.00		0.00	0.00
Packaging Hours :	0.00	0.00	0.00			
Packaging Cost :	0.00	0.00	0.00		0.00	0.00
OverHead Hours :	0.00	0.00	0.00			
OverHead Cost :	0.00	0.00	0.00		0.00	0.00
CNC Hours :	0.00	0.00	0.00			
CNC :	0.00	0.00	0.00		0.00	0.00
Misc. Hours :	0.00	0.00	0.00			
Misc. :	0.00	0.00	0.00		0.00	0.00
<hr/>						
Burden :	0.00	0.00	0.00			
<hr/>						
Total Cost :	0.00	0.00	0.00			
Margin :	0.000	0.000				
Selling Cost :	0.00	0.00				

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00